

Date: Wednesday, 07/01/2009 12:44:04 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DECK PLATE AND TIE DOWN KIT	
Job Number :	44452			
Estimate Number :	12873			
P.O. Number :		Part Number :	D350616013	
This Issue :	07/01/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D350-616 REV.E	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	39194	Drawing Revision :	E	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	15/01/2009	Qty: 2 Um: Each
Written By :				
Checked & Approved By :	<u>JUD 09.01.09</u>			
Comment :	Est A 07.05.22 coss issue EC Est Rev:B 08-12-10 rev.E as per dwg DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



for JUD 09/01/15

**Comment:** DOCUMENT CONTROL

Create labels per PPP D350-616-013 CHG 002

Sorlos

2.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D350616015

Deck Plate

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Deck Plate Kit

CHG 002

Qty Part Number Description Batch

1 D350-616-015 Deck Plate Kit

461006

JS 09/01/15

4.0

D2360

Litter Tie Down Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Litter Tie-down

Batch

42883

JS 09/01/15

5.0

D3179041

Fwd Litter Tie Down

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fwd Litter Tie Down

batch:

43973

JS 09/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 12:44:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE AND TIE DOWN KIT

Job Number: 44452

Part Number: D350616013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8091015 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with red decal per PPP D350-616-013 CHG 002
and Stock

Rev E

9/1/16

2x
SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/19

Job Completion



MF 09-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D3494-1	STUB COVER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		4	MS35207-264	SCREW
		10	NAS1149D0363J	WASHER (or AN960JD10)

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BY: D. SHEPHERD (DE # 02)

DATE: 08.11.07
CERT. NO.: SH96-10
ISSUE NO.: 2

E	MAKE DSI 9310 STANDARD; D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	D350-616	SHEET 1 OF 12
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GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011	31.3 lb	17.3 in	541.5 in-lb	63.8 in	1996.9 in-lb
Full Litter Kit	14.19 kg	0.44 m	6.24 m-kg	1.62 m	22.99 m-kg
D350-616-013	6.3 lb	15.4 in	97.0 in-lb	52.0 in	327.6 in-lb
Deck Plate & Tie Down	2.86 kg	0.39 m	1.12 m-kg	1.32 m	3.78 m-kg
D350-616-015	2.8 lb	15.6 in	43.7 in-lb	53.0 in	148.4 in-lb
Deck Plate Kit	1.27 kg	0.40 m	0.51 m-kg	1.35 m	1.71 m-kg
Person Approximate CG	lb	18 in	in-lb	72 in	in-lb
	kg	0.46 m	m-kg	1.88 m	m-kg

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
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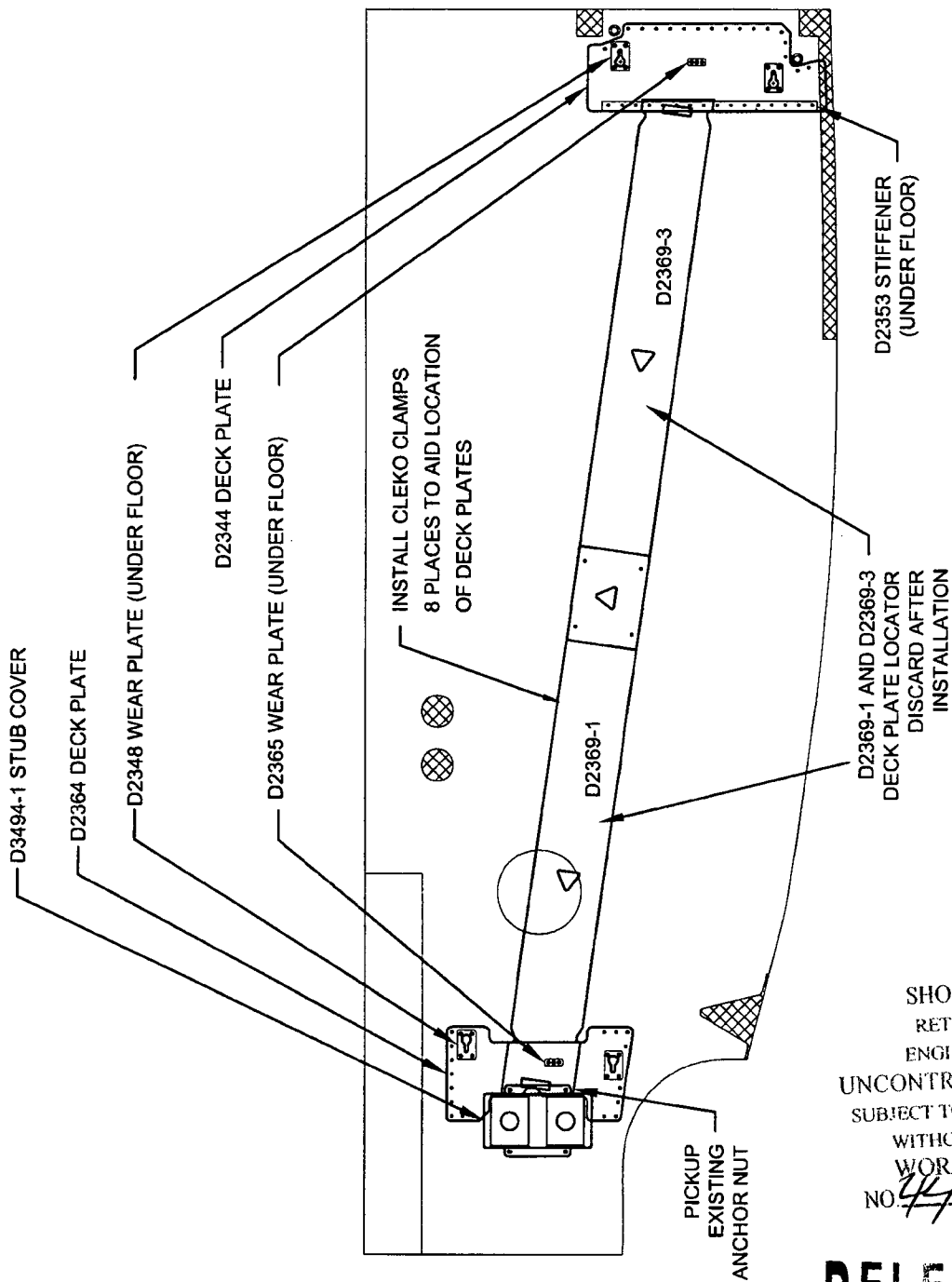


FIGURE 1

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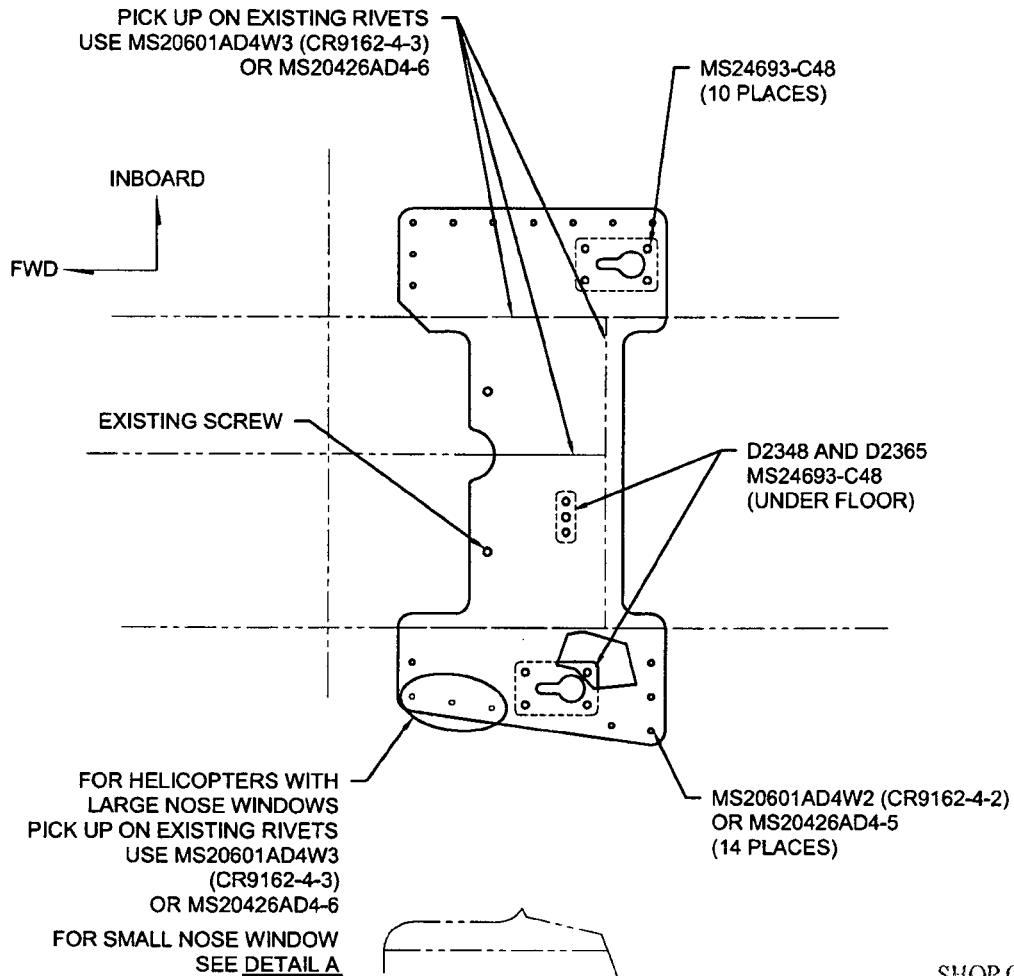
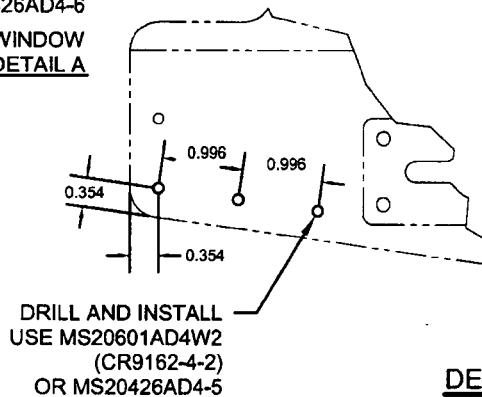


FIGURE 2



DETAIL A

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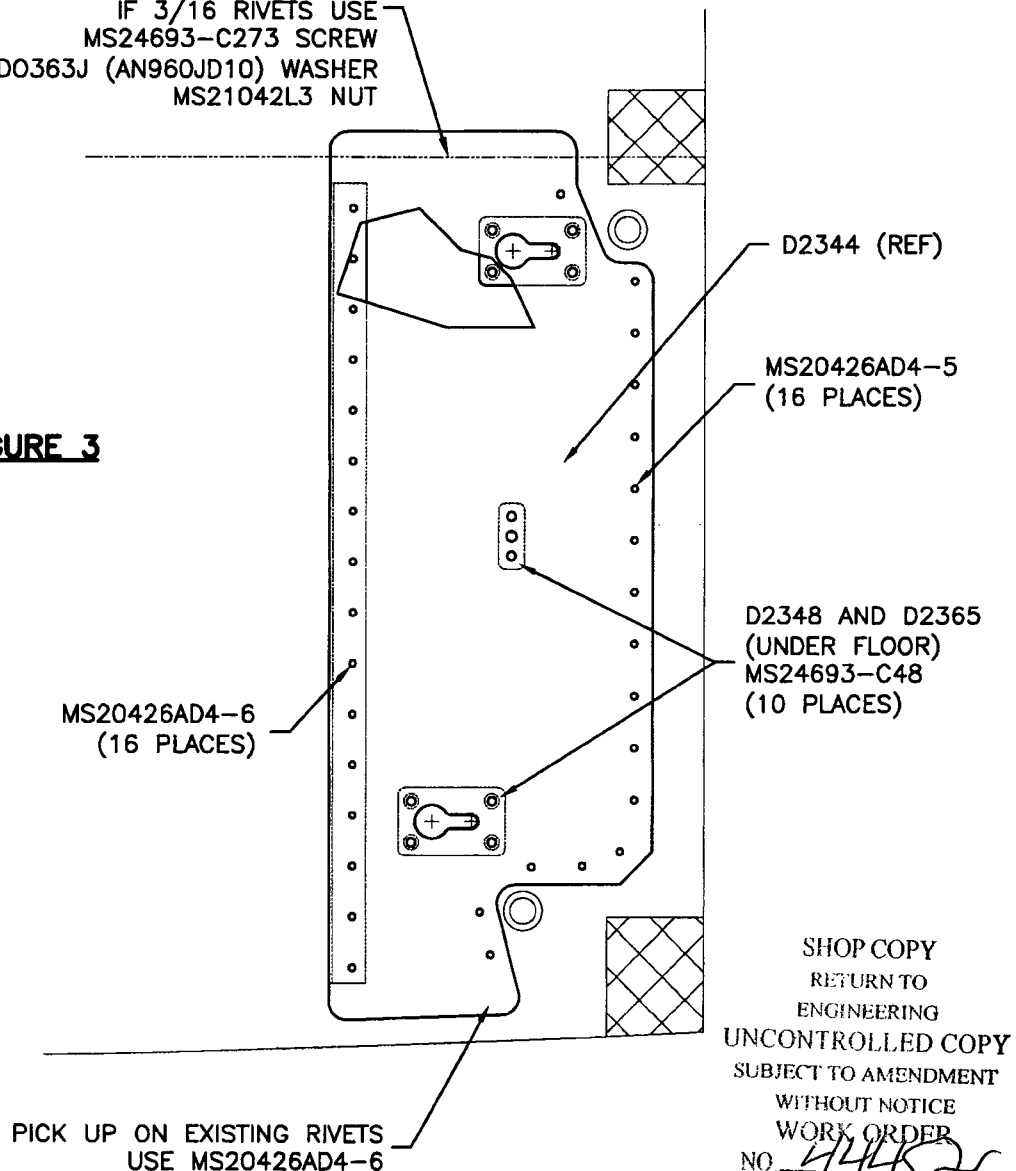
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PICK UP ON EXISTING RIVETS
 IF 5/16 RIVETS USE
 MS20426AD5-7/MS20426AD5-8
 IF 3/16 RIVETS USE
 MS24693-C273 SCREW
 NAS1149D0363J (AN960JD10) WASHER
 MS21042L3 NUT

FIGURE 3



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FIGURE 4: LITTER TIE DOWN INSTALLATION

D3494-1 STUB COVER
PICK UP ON EXISTING INSERTS:
USE EXISTING SCREWS OR
MS35207-264 SCREWS (4)
AND NAS1149D0363J (AN960JD10)
WASHERS (4)

D3179-041
LITTER TIE DOWN
(NON-LOCKING)
ACCEPTABLE TO TRIM
D3179-041 AS REQUIRED
FOR FIT AS LONG AS
A MINIMUM EDGE DISTANCE
OF 0.250" IS MAINTAINED
FROM THE EDGE OF ALL
HOLES AND SLOTS.
TOUCH UP WITH PRIMER &
PAINT IN ACCORDANCE WITH
AIRCRAFT MAINTENANCE
MANUAL PRIOR TO FINAL
INSTALL.

D2360
LITTER TIE DOWN
(LOCKING)

INBOARD

FORWARD

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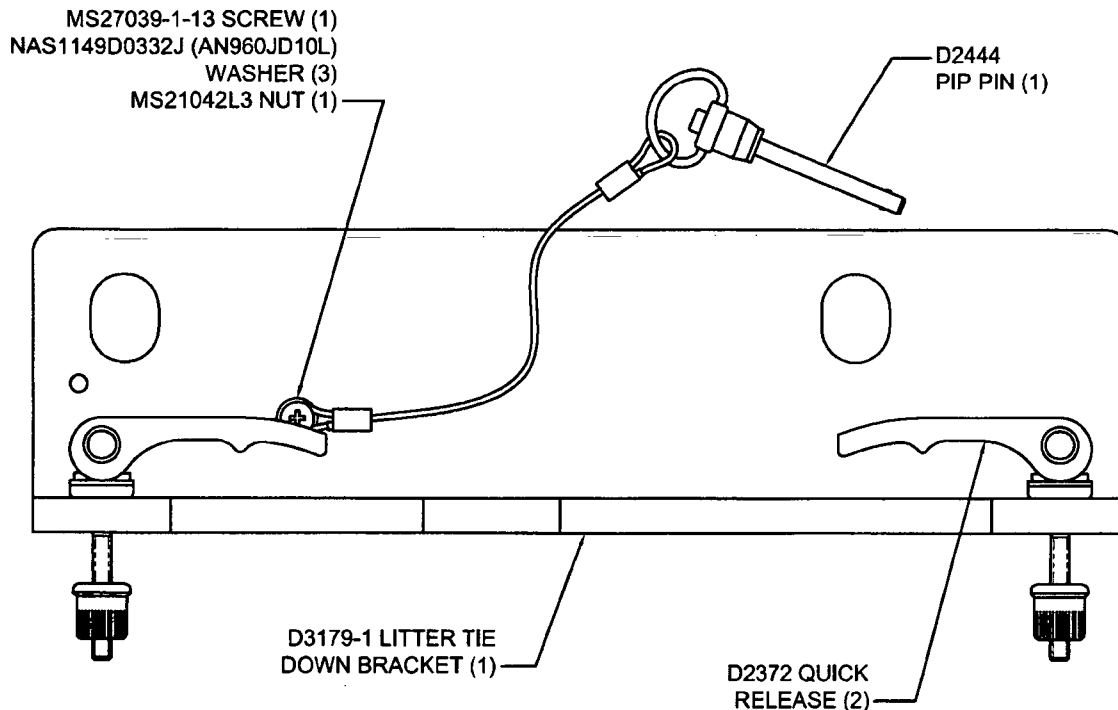


FIGURE 5: D3179-041 FWD LITTER TIE DOWN BRACKET
(PART REFERENCE)

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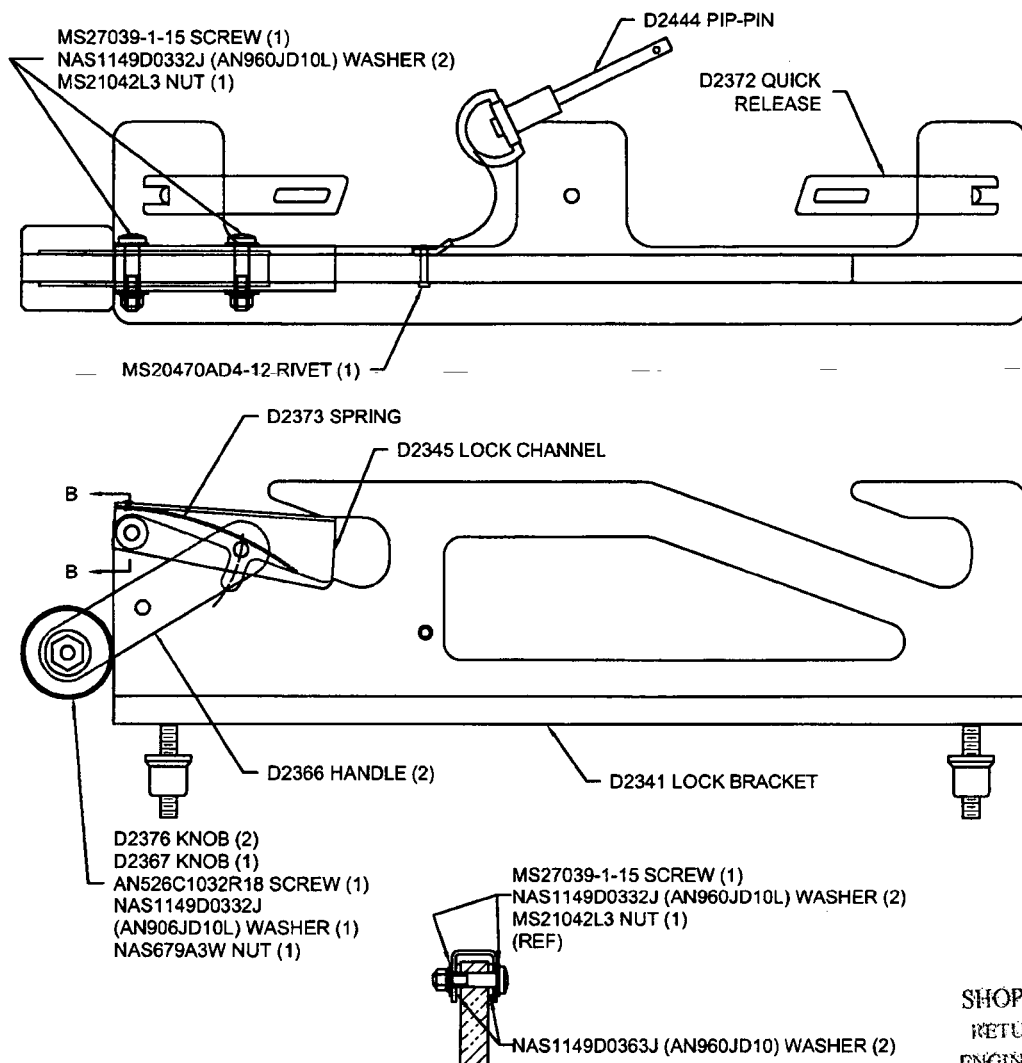
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SECTION B-B

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

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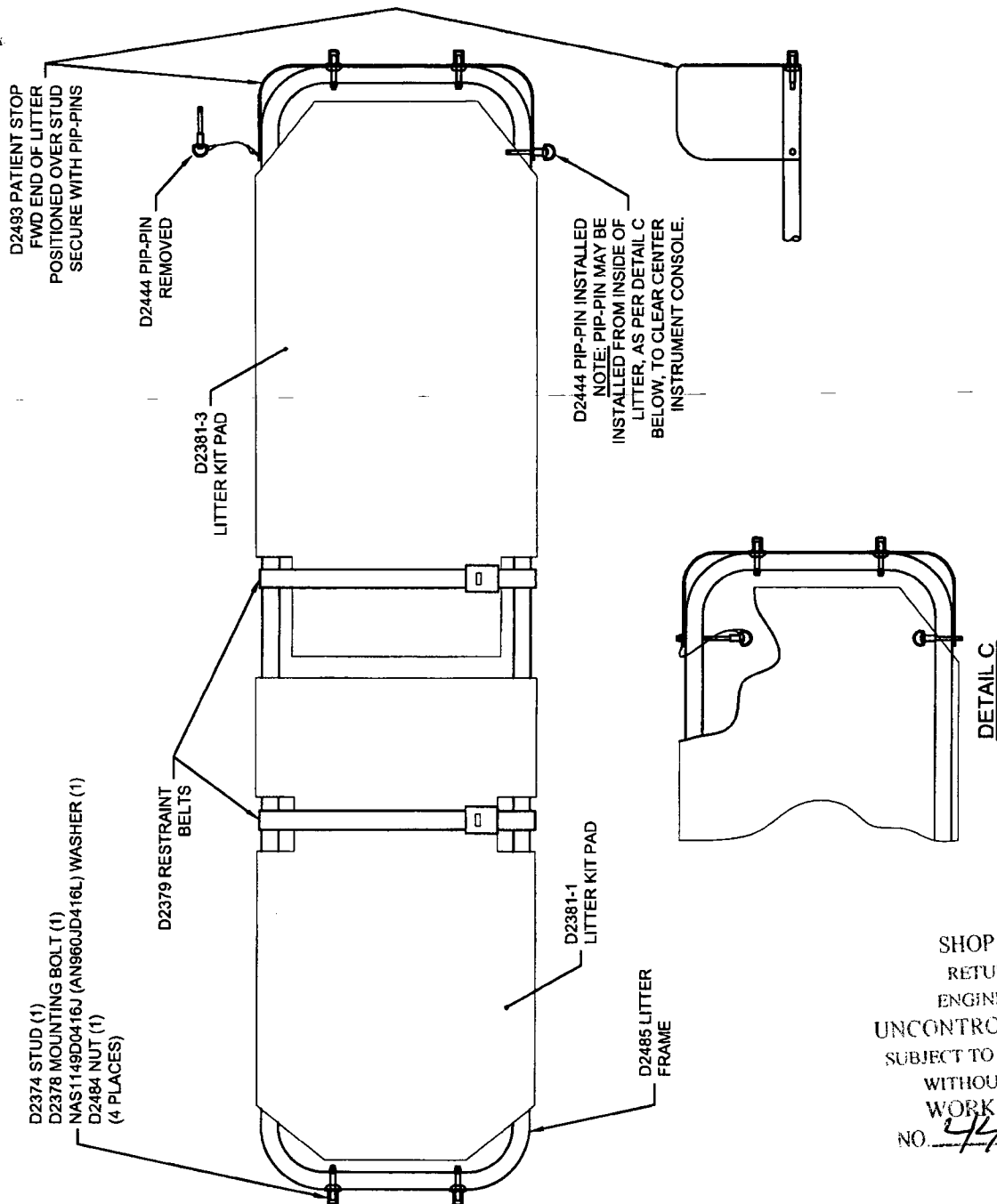


FIGURE 7: D2370 LITTER ASSEMBLY
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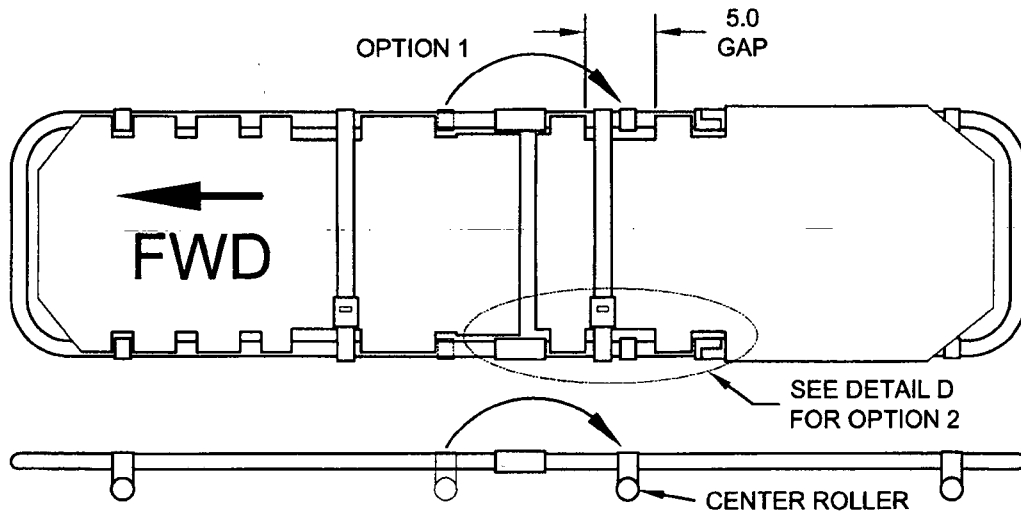
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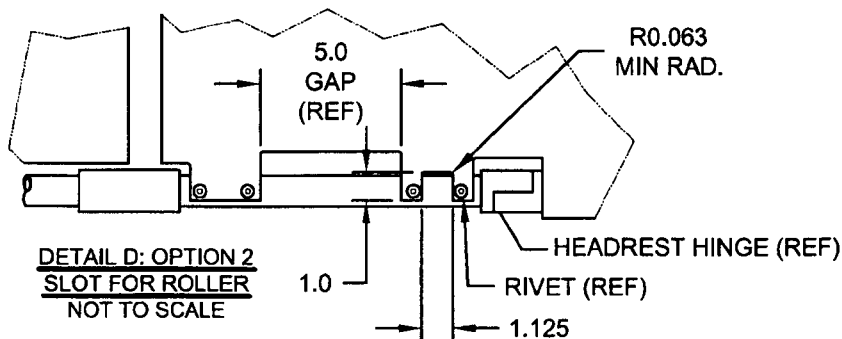
COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.



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FIGURE 8: CENTER ROLLER RE-LOCATION

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COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 9 & 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 10.

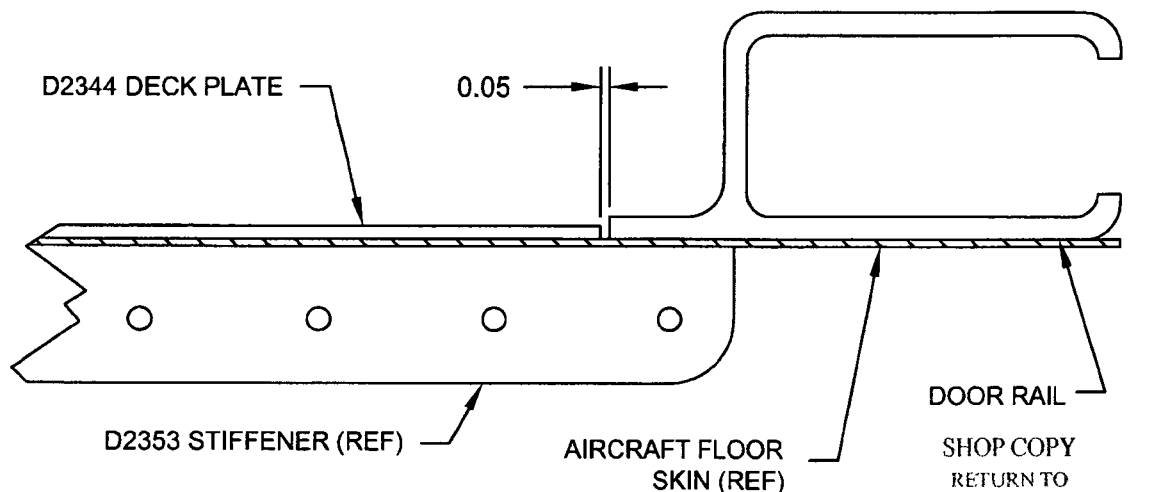


FIGURE 9
VIEW LOOKING AFT

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COMPATIBILITY WITH SLIDING DOORS

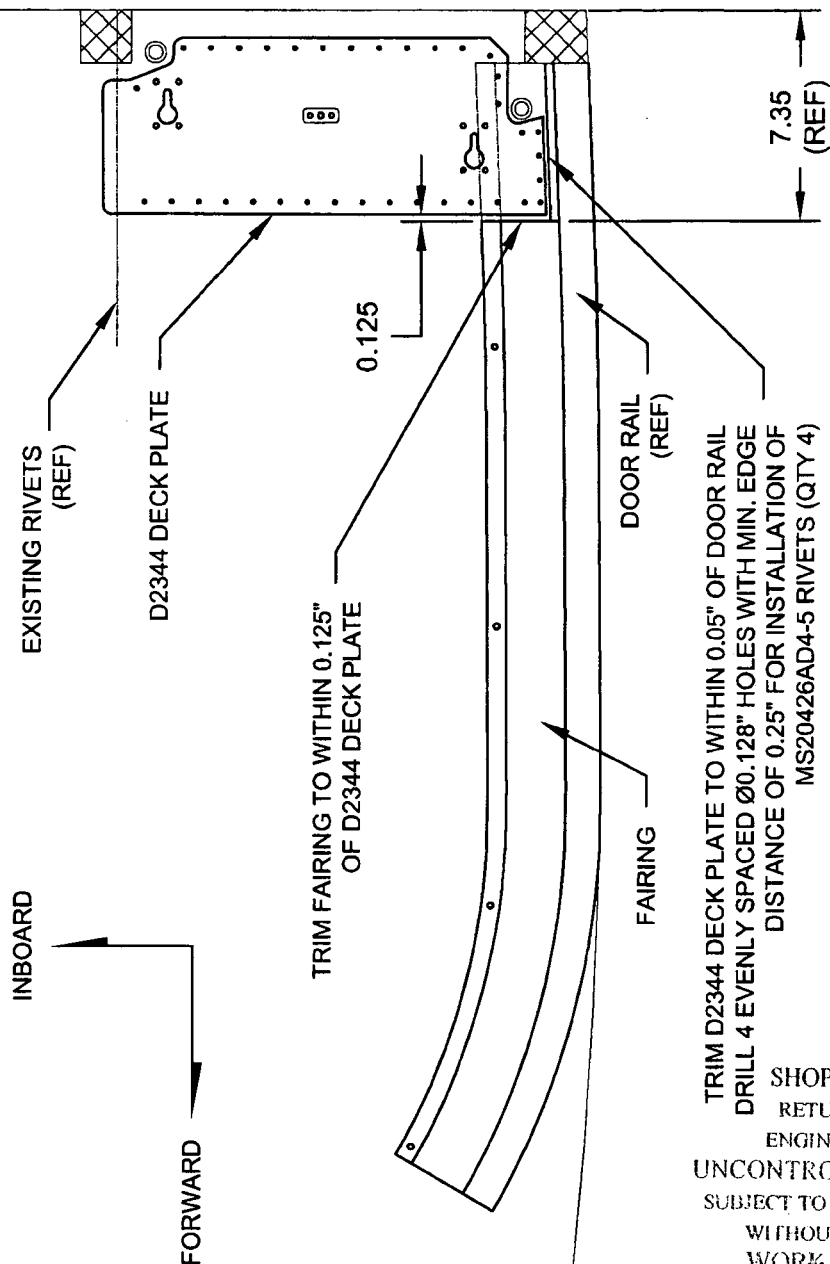


FIGURE 10

TRIM D2344 DECK PLATE TO WITHIN 0.05" OF DOOR RAIL
 DRILL 4 EVENLY SPACED Ø0.128" HOLES WITH MIN. EDGE
 DISTANCE OF 0.25" FOR INSTALLATION OF
 MS20426AD4-5 RIVETS (QTY 4)

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 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

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 BY: D. SHEPHERD (DE # 02)
 DATE: 08.11.07
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